

Date: Thursday, 5/10/2007 2:25:41 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE
Job Number	32281		Part Number	D265633
Estimate Number	10617		Drawing Number	D2656 REV D
P.O. Number	N/A		Project Number	N/A
This Issue	5/10/2007	S.O. No.	N/A	
Prsht Rev.	NC		Drawing Revision	D
First Issue	N/A		Material	N/A
Previous Run	29452		Due Date	5/30/2007
Written By			Qty:	25
Checked & Approved By	KJ 07.05.10		Um:	Each
Comment	Est: D 02.10.25 Re-format KJ Est Rev:E 06-08-21 Now On Water JET JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1010S20GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 0.4074 sf(s)/Unit Total : 10.1850 sf(s) 1010/1025/A21/6aA SHEET 20 GUAGE Batch: M104184 (17) M102684 (6) M103258 (3) SAD 07/05/12
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326. 2-Identify as D2656-33.

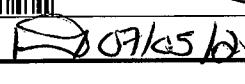
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/05/16	4	I piece was not good	05042	Scrap & destroy	07/05/16 John	07/05/16 05042	07/05/16 05042	07/05/16	

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARSHOE
Job Number: 32281		Part Number: D265633
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>2005-12 25</i> 
7.0	POWDER COATING	POWDER COATING <i>M101601</i> 
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>M-L 07/05/23</i> 
9.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>25X</i> 
10.0	QC21	FINAL INSPECTION/W/O RELEASE <i>FP-15 m-l 07/05/23</i> 
Comment: FINAL INSPECTION/W/O RELEASE		<i>25</i> 
Job Completion 		<i>U 0705.25</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

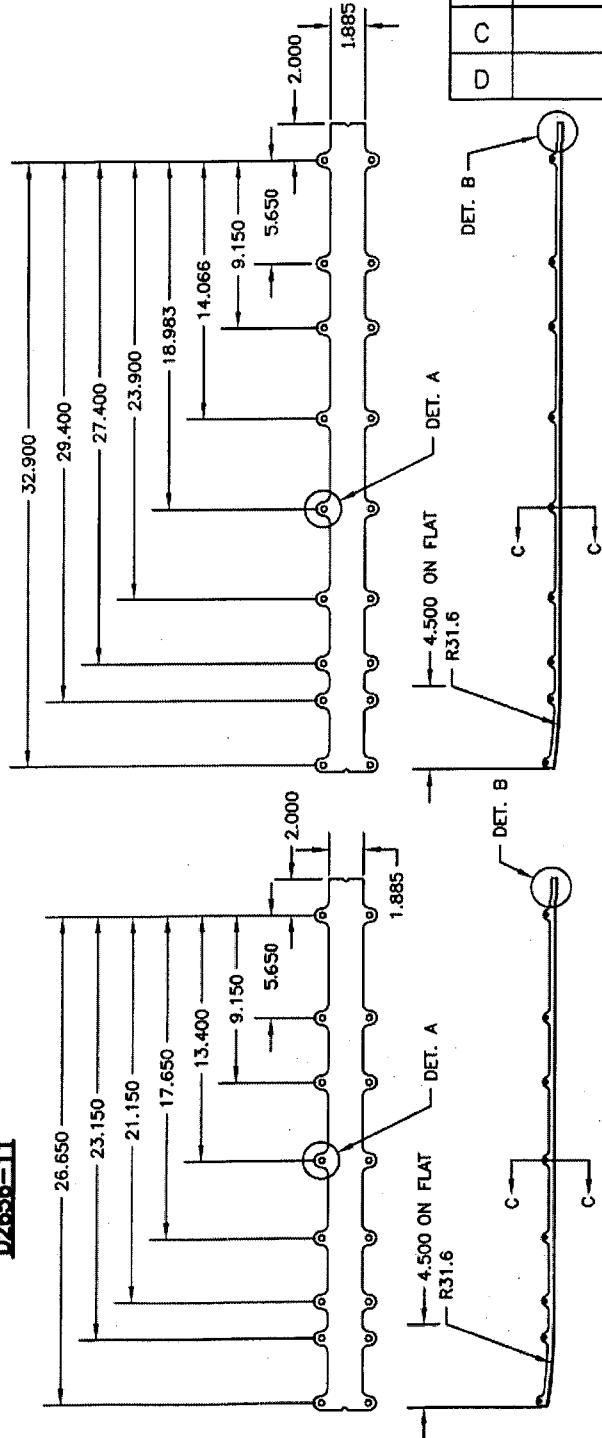
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

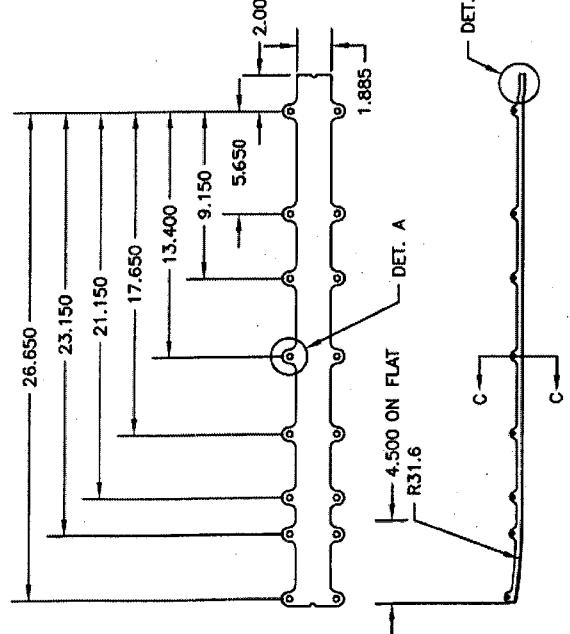
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DS	CP	
CHECKED	APPROVED	DRAWING NO. REV. D D2656
		SHEET 1 OF 4
DATE	TITLE	SCALE
05.08.17	WEARSHOE	1:10
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

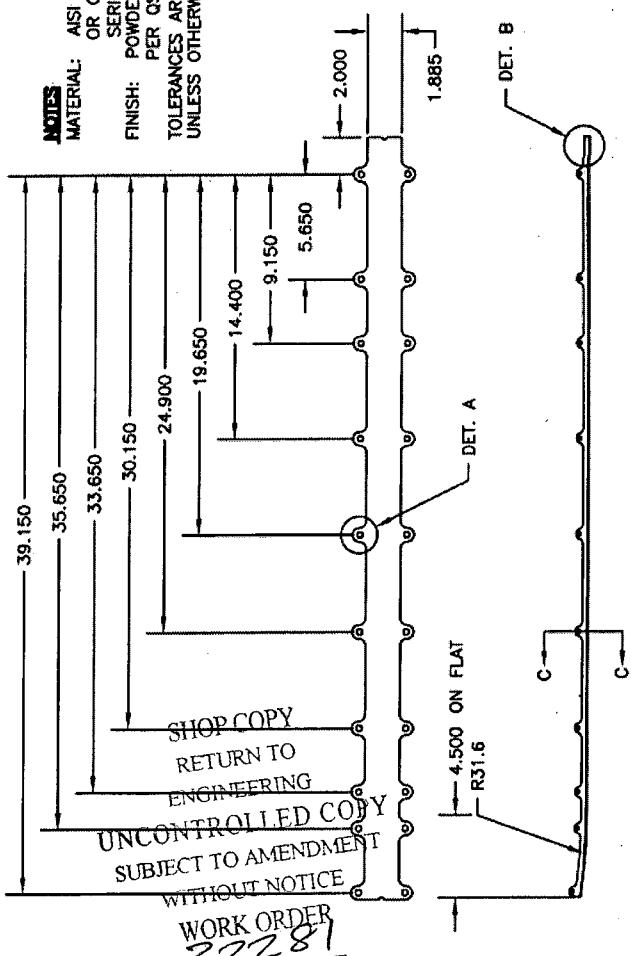
D2656-13



D2656-11



D2656-15



**NOTES:**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A1008  
OR CSA G40-21, 3BW/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANTEX (4.5.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED.

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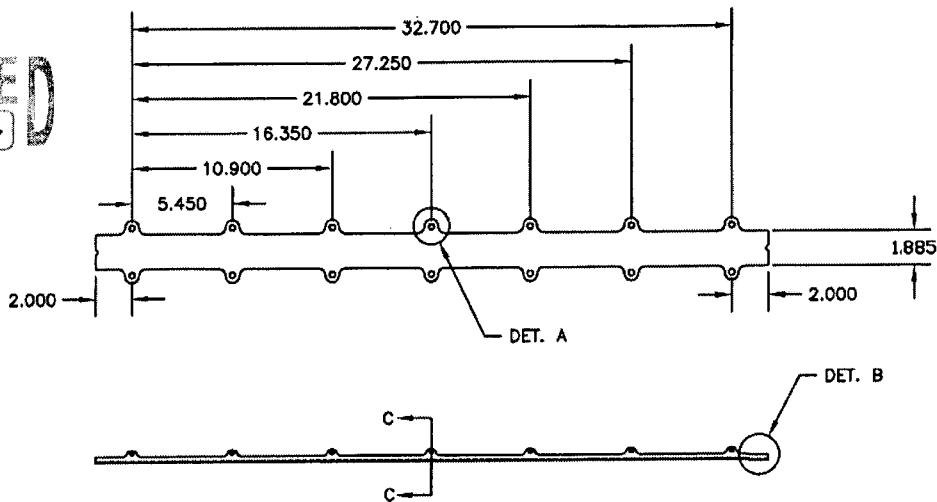
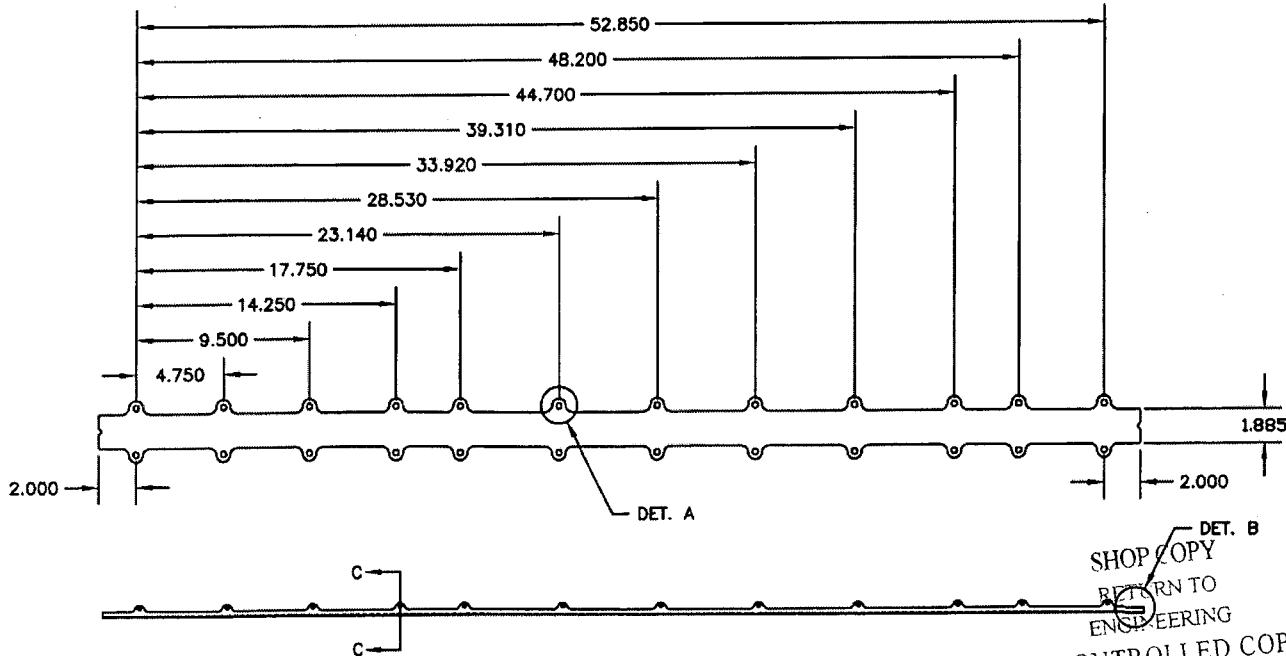
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WORK ORDER  
NO. 32281



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DS	CP	PORT HADLOCK, WA
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		REV. D SHEET 2 OF 4
DATE		TITLE
05.08.17		WEARSHOE
		SCALE 1:10

**RELEASED**  
05.07.06**D2656-21****D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

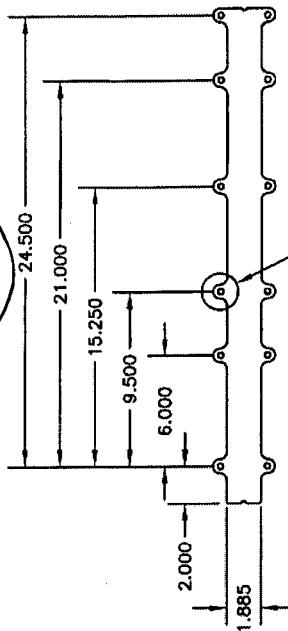
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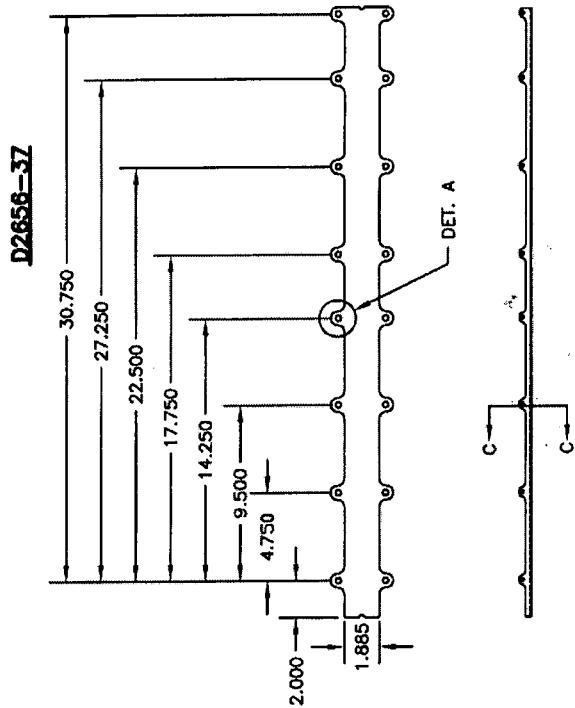
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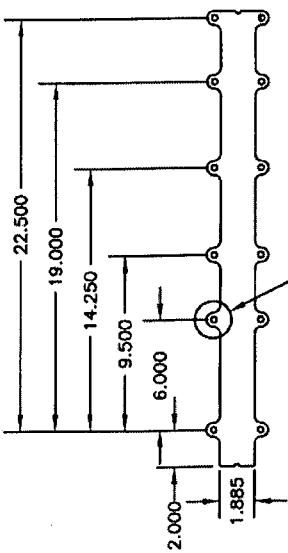
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DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2656
		REV. D
DATE		SHEET 3 OF 4
05.08.17		WEARSHOE
		SCALE 1:10



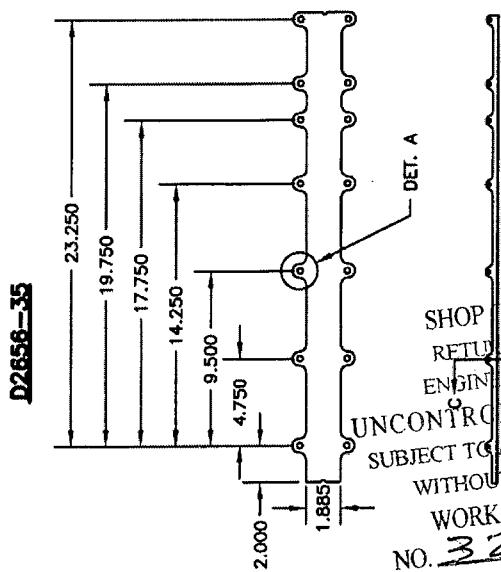
D2656-31



D2656-37



D2656-31



D2656-35

NOTES:  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
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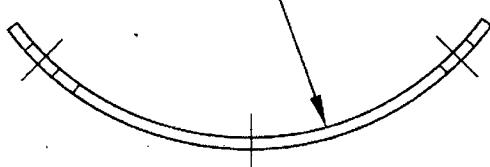
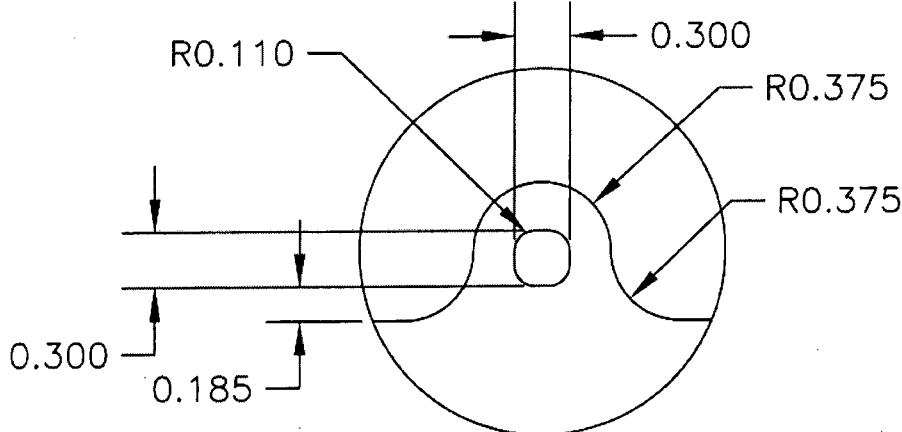
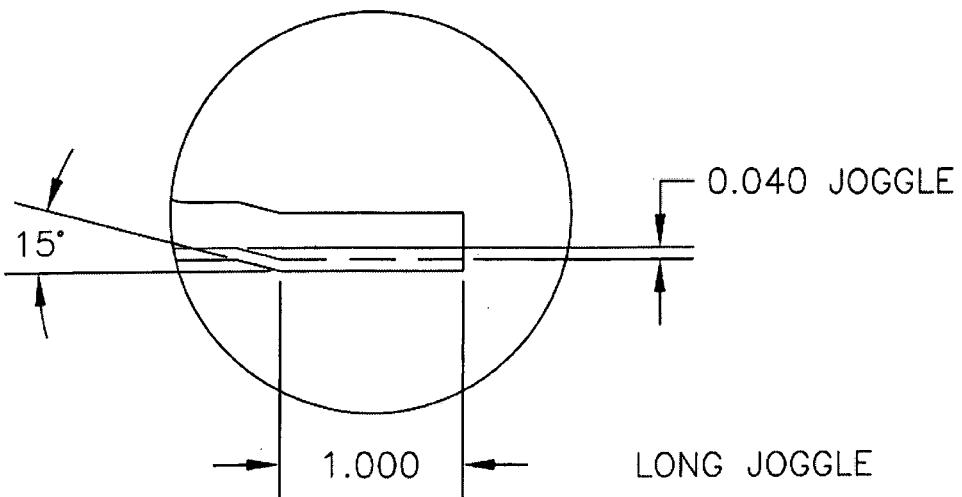
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CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

R1.62

**RELEASED**  
05.09.06 *AA*DETAIL ADETAIL B

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DART AEROSPACE LTD	Work Order:	32281
Description: <del>WEARSHOE</del> WEARSHOE	Part Number:	D265633
Inspection Dwg: D2656 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 24.500	+/- 0.010	24.500	✓		M-T	
B 21.000	+/- 0.010	21.000	✓		M-T	
C 15.250	+/- 0.010	15.250	✓		M-T	
D 9.500	+/- 0.010	9.492	✓		Vern	
E 6.000	+/- 0.010	6.000			Vern	
F 2.000	+/- 0.010	2.001	✓		Vern	
G 1.885	+/- 0.010	1.888	✓		Vern	
H 0.300	+/- 0.010	0.299	✓		Vern	
I 0.300	+/- 0.010	0.300	✓		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAD	Audited by:	<i>BB</i>	Prototype Approval:	N/A
Date:	07/05/12	Date:	07.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

